

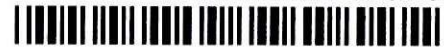


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Tel (613) 632-5200

D3506-3

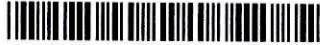
Job Sheet 179704



Part No: D3506-3

Job Qty: 12 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 06-05-31 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		7/18/18	0.00	0.00	Start Up Waterjet		18/07/16
100	Waterjet	12 pcs		7/18/18	0.00	0.43	Waterjet1		18/07/16
110	QC	12 pcs		7/18/18	0.00	0.00	QC2 Waterjet-2		18/07/16
120	CNC Vertical Machining	12 pcs		7/18/18	0.00	0.86	HAAS1-3		18/08/11
130	QC	12 pcs		7/18/18	0.00	0.00	QC2 Machining-2		18/08/11
140	QC	12 pcs		7/18/18	0.00	0.00	QC8 Machining-2		18/08/11
150	Small Fab	12 pcs		7/18/18	0.00	0.14	Small Fab-4		18/08/11
160	QC	12 pcs		7/18/18	0.00	0.00	QC5		18/08/11
170	HandFinish	12 pcs		7/18/18	0.00	0.20	HandFinish1		18/08/11
180	QC	12 pcs		7/18/18	0.00	0.00	QC7-2		18/08/11
190	Packaging	12 pcs		7/18/18	0.00	0.00	Packaging3-1		18/08/11
200	QC21-SA	12 Ea		7/18/18	0.00	0.00	QC21		18/08/11

Part Op 100 - 1-Cut as per Dwg D3506 Dwg Rev: A Prog Rev: 1 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - Machine as per Folio FA640 and Dwg D3506

130 - QC2- Inspect parts off machine FAI/FAIB

140 - QC8- Inspect parts - second check

150 - C'sink as per Dwg D3506 (On Flat side)

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1

180 - QC7-Inspect Chemical Conversion Coat

190 - Identify as per dwg & Stock Location: LOCATION : LG001

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.100	6061-T6 .100 Sheet	.0936 sf (.0078 ea)	90-Start up Operation	5025678

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.100	0	44	0

Part Specifications

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework ☐			
NCR No. _____		Skid-tube Machining ☐		Cross tube Small Fab ☐	
Date: _____		Water Jet ☐		Prod. Eng. Coord. ☐	
Description 1		Supplier ☐		Engineering Quality Other ☐	
		MRB (QSI042) Approval			
		Completed By			
		Lead hand / Supervisor Approval Verification			
		QC / QA Coordinator Approval			

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Container No: S091971
Part: D3506-3
Job No: 179704
Serial No/Batch: S091971
Revision: _____
Inspector: _____
Exp Date: _____
Instructions: _____

Date: 07/16/18

Root Cause			
Environment ☐	No Re-verifi. ☐		
Design ☐	Operator ☐		
Doc/Data ☐	Offset/Setup ☐		
Equip/Tooling ☐	Supplier ☐		
Handling/Pre ☐	Training ☐		
Material ☐	Use for Testing ☐		
Internal Transport ☐	Poor Information ☐		
Tribal Knowledge ☐	Rushing ☐		
LOA ☐	Product Improvement ☐		
Substation ☐	Process Improvement ☐		
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐		

Bending ☐	Set-up ☐	/Surge ☐	Positioned Wrong ☐
Centre Not Concentric ☐	BOM/Route ☐	am ☐	Outside Dimensions ☐
Cracks ☐	Broken/Damage/Defect ☐	Grain ☐	Over/Under tolerance ☐
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Weld ☐	Part Incorrect ☐
Cuffs ☐	Contamination ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Crushing ☐	Countersink ☐	Out of Sequence ☐	Part Moved ☐
Heat Treat ☐	Cut Too Short ☐	Off-set ☐	Drawing ☐
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Mislabeled ☐	Finish ☐
Marks/Chatter ☐	Drill Holes ☐	Fit/Function ☐	Misread ☐
OTHER: ☐		Misaligned/off center ☐	Turning Sequence ☐

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.128inches + 0.005 - 0.001	0.133 0.127	0.129"	
2	Doubler	0.277inches + 0.006 - 0.001	0.283 0.276	0.278"	
3	Doubler	0.750inches ± 0.010	0.760 0.740	0.748"	
4	Doubler	1.500inches ± 0.010	1.510 1.490	1.500"	
5	Doubler	0.375inches ± 0.010	0.385 0.365	.375"	
6	Doubler	0.750inches ± 0.010	0.760 0.740	0.748"	
7	Doubler	0.250inches ± 0.010	0.260 0.240	0.250"	
8	Doubler	0.098inches ± 0.010	0.108 0.088	0.099"	

JP 18/08/11 Plex 6/21/18 7:16 AM Dart.lajeunesse.marie